

303 2.00

Work Order ID 77073

77073

November-25-11 10:26:39 AM

Item ID: D3912-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt
 Start Date: 25/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								

100 0.00
100 12
 Doosan Memo 0.00
 Doosan Lathe TURN AS PER FOLIO FA871 AND DWG
 Prog Rev: 13
 Dwg Rev: 13 12/01/04
 Deburr as required

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 12
 QC Memo 0.00
 Quality Control 12/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 12-01-09		(12)			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							12/1/09
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/1/10 ME 12-01-09

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NOTE: Date & initial all entries

Picklist Print

November-25-11 10:26:43 AM

Page 1

Work Order ID: 77073

77073

Parent Item: D3912-1

D3912-1

Parent Item Name: Eyebolt

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	11.9310	0.25	3.157895			

M303R2 000

303 ROUND BAR 2"

**

12/01/104

Location

Loc Qty

Loc Code

MAT029

11.931

116656

1.427

116700

10.504

324

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DART AEROSPACE LTD		Work Order: 77073
Description: Eyebolt		Part Number: D3912-1
Inspection Dwg: D3912	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.127	/		SL-9	
Ø0.700	+/-0.010	Ø.695	/			
Ø0.500	+/-0.010	Ø.499	/			
0.90	+/-0.030	.90	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.225	/			
0.75	+/-0.030	.752	/			
0.970	+/-0.010	.972	/			
1.72	+/-0.030	1.721	/			
1.20	+/-0.030	1.20	/			
0.625	+/-0.010	.625	/			
2.23	+/-0.030	2.229	/			
R0.13	+/-0.030	R.140	/			
R0.015	+/-0.010	R.015	/			
0.625	+/-0.010	.625	/			
Ø0.650	+/-0.010	Ø.650	/			
1.100	+/-0.010	1.100	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/			
1.00	+/-0.030	1.00	/			
0.25	+/-0.030	.250	/			
0.88	+/-0.030	.880	/			
0.11	+/-0.030	.115	/			
Ø0.719	+0.010/-0.000	Ø.724	/			

Measured by: SL	Audited by: SL	Preliminary Approval:
Date: 12/01/04	Date: 12-01-09	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	

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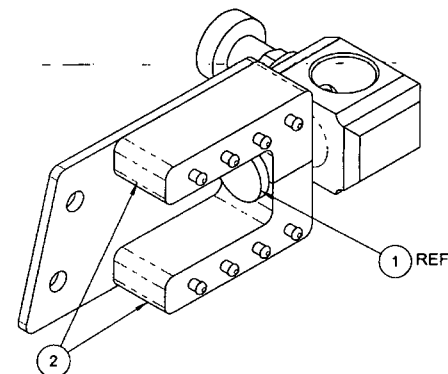
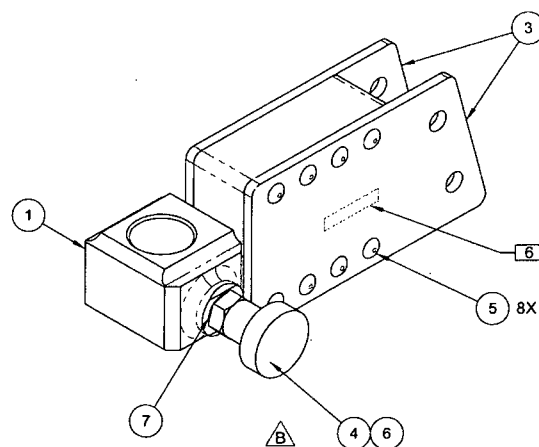
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 770734CJ

11/11/25

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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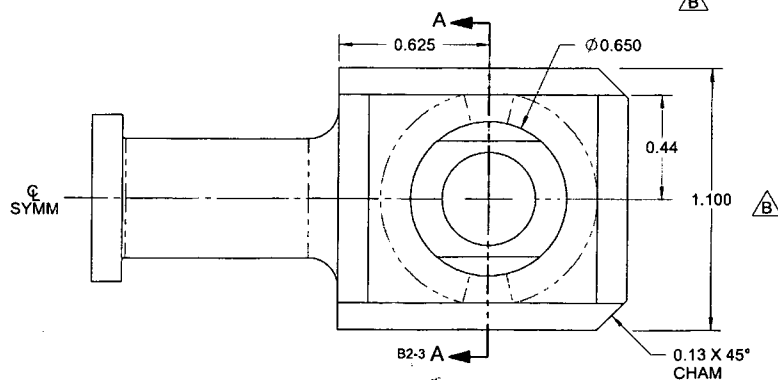
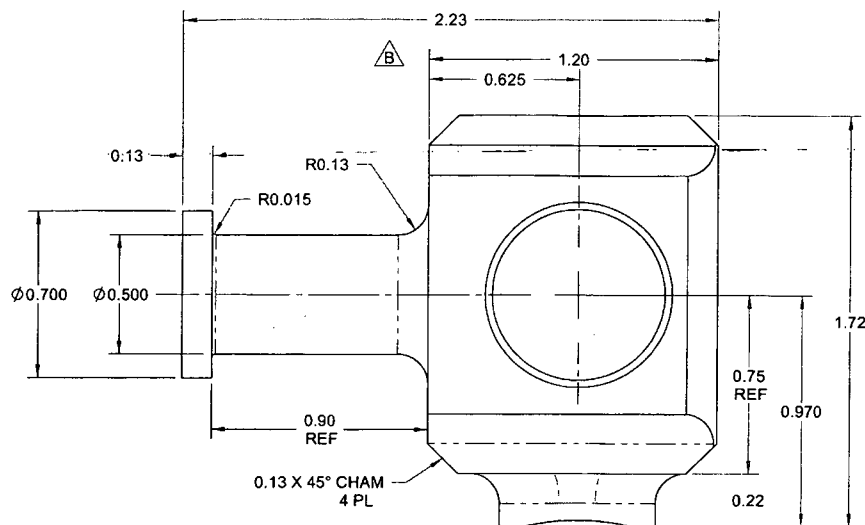
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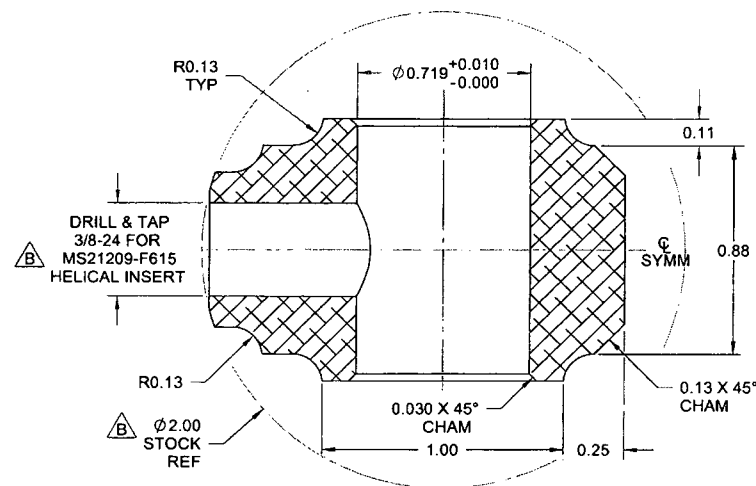
77073



D3912-11 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	<i>AJS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3912	SHEET 2 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	EYEBOLT RECEIVER ASSY	NTS
DE APPR	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.06.28		

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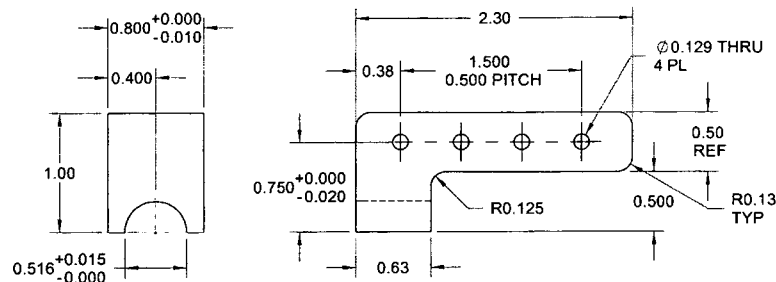
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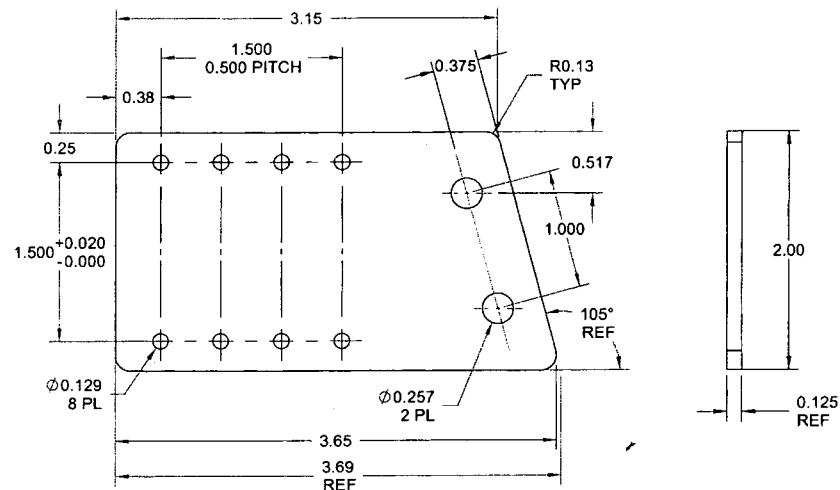
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NOTE: Date & initial all entries

77073



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
jmd

DESIGN	ASS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO.	REV. B
CHECKED	ASS	D3912	SHEET 3 OF 3
MFG. APPR.	ASS	TITLE	SCALE
APPROVED	ASS	EYEBOLT RECEIVER ASSY	NTS
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